

FOR TEST (AIRBORNE ROAD TEST)

| | | | |
|----------------------------------|--|-------------------------------|------------|
| DART AEROSPACE LTD | | Work Order: 23640 | # 041 |
| Description: Arm Weldment | | Part Number: D3379-044 | |
| #05.06.21 C | | | |
| Dwg: D3379 Rev. A page 1 | | Qty: 4 | # 05.06.21 |
| | | Page 1 of 1 | |

| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | |
|------|-------------|--|---------------|-------------|-------------|-------|---|-----------|----------------|--------|---|---------|---------|---------------|--|----------|---|
| 1 | DC | Issue Traveler Remove D3379-043 / D3379-1 from inventory | MF | 05.06.21 | 4 | | | | | | | | | | | | |
| 2 | MFA | Assemble and weld using welding Jig DT8764 as per Dwg D3379 Pick: + correct angle as per D3379 rev. C <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3379-043</td><td>Lever Assembly</td><td>B22470</td></tr><tr><td>1</td><td>D3379-1</td><td>Support</td><td>B22817 B22471</td></tr></table> Identify as D3379-041 | Qty | Part Number | Description | Batch | 1 | D3379-043 | Lever Assembly | B22470 | 1 | D3379-1 | Support | B22817 B22471 | | 05/08/22 | 4 |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | |
| 1 | D3379-043 | Lever Assembly | B22470 | | | | | | | | | | | | | | |
| 1 | D3379-1 | Support | B22817 B22471 | | | | | | | | | | | | | | |
| 3 | QC5/9 | Inspect work to Step 2 | MF | 05/08/22 | 4 | | | | | | | | | | | | |
| 4 | FP | Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask holes | MF | 05.11.14 | 4 | | | | | | | | | | | | |
| 5 | QC3 | Inspect Powder Coat | MF | 05.11.14 | 4 | | | | | | | | | | | | |
| 6 | ST | Identify and Stock Return to inventory for Airborne Road Test. | CPL | 05.11.16 | 4 | | | | | | | | | | | | |
| 7 | AC | Charge to project number P601-571/-572 Cost / part 99.53 | SAC | 05.11.21 | 4 | | | | | | | | | | | | |
| 8 | DC | Close W/O 69.87 Inspect Level 21 | MF | 05/11/21 | 4 | | | | | | | | | | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A | 05.02.03 | New issue | KJ/JLM | |

PRELIMINARY ISSUE

UNDER REVIEW

#05.06.02

CANCEL FOR

THIS W/O

#05.06.21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

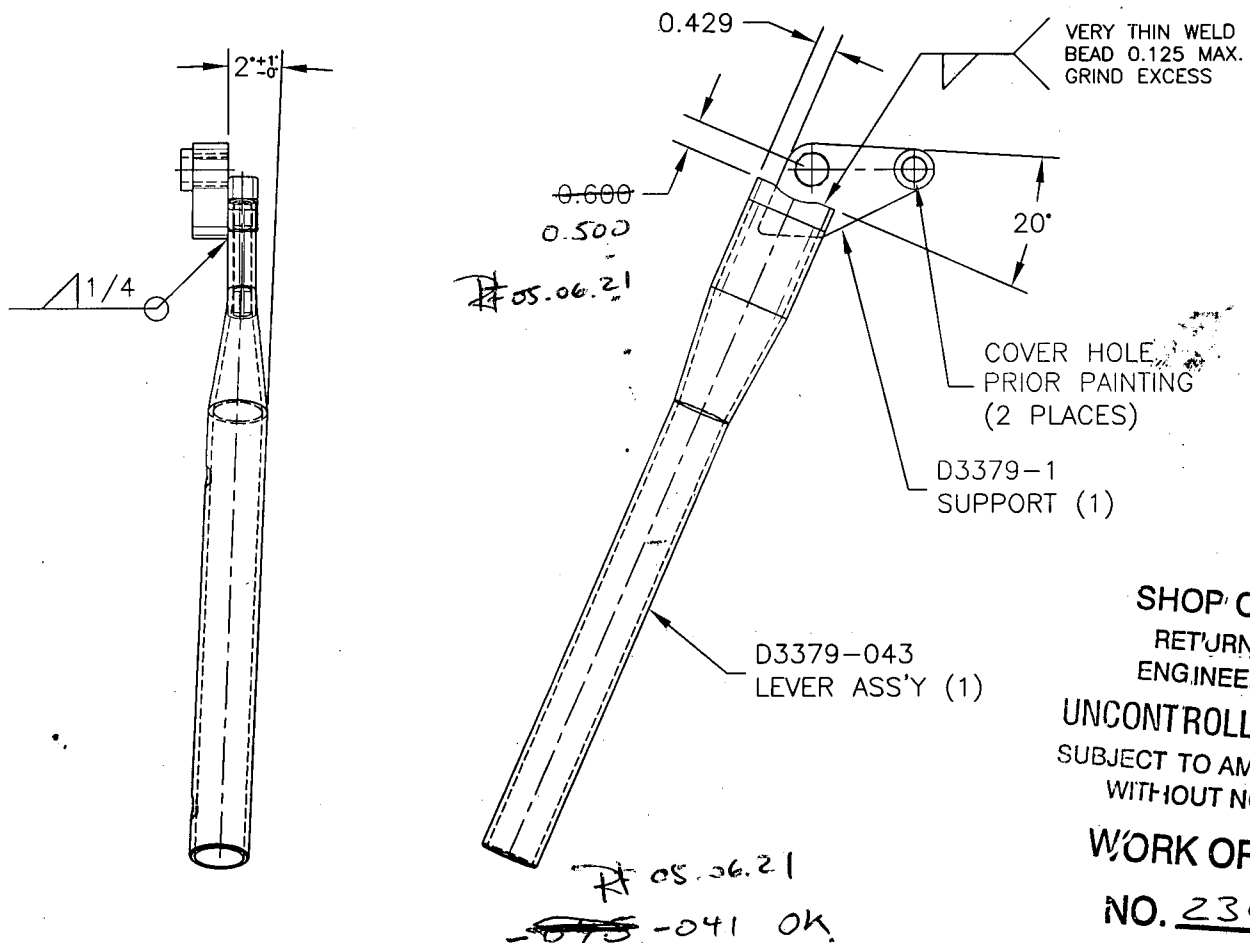
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

| | | | |
|------------------|----------|--|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3379 | REV. C SHEET 1 OF 4 |
| DATE 05.05.27 | | TITLE ARM WELDMENT | SCALE 1:1 |
| A | 04.12.13 | NEW ISSUE | |
| B | 05.02.25 | RE-DESIGN D3379-5 | |
| C | 05.05.27 | 2" WAS 4" | |



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23640

D3379-041 ARM WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

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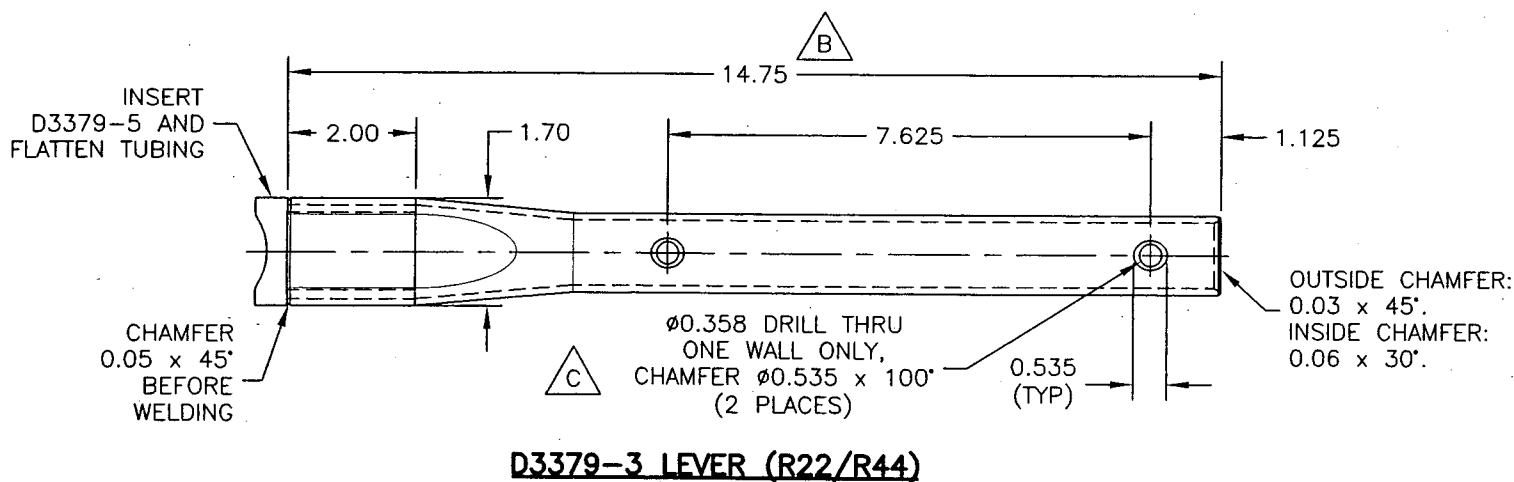
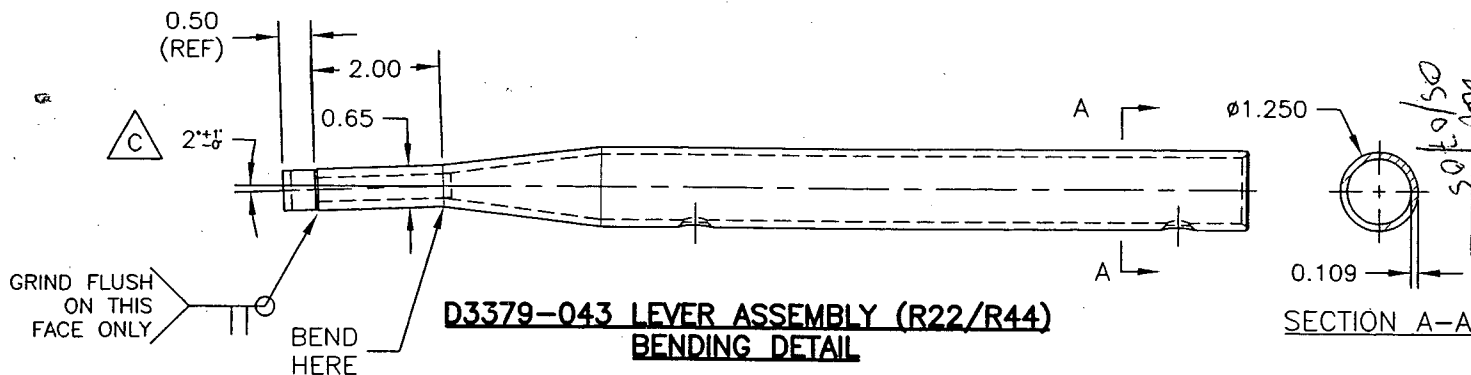
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DART

| | | |
|----------|--------------|-----------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD |
| CHECKED | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| DATE | TITLE | REV. C |
| 05.05.27 | ARM WELDMENT | D3379 |
| | | SHEET 3 OF 4 |
| | | SCALE |
| | | 1:3 |

RELEASED



NOTES:

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.250W.109)
- 2) WELD PER QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

NO. B23640

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:32 am

Work Order No : 0023640
Project Name : D3379-041
Project For : WK526
Work Order Type : Main
Main WO Number :
House Part Number : D3379-041
Description : Arm Weldment
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 06-21-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 15.75 | 100.00 | | |
| Production Cost : | 0.00 | 252.10 | 100.00 | 0.00 | 252.10 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 252.10 | 100.00 | | |
| Margin : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 252.10 | | | |

| | | |
|--------------------------|-----------|------------|
| | Estimated | Actual |
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | (-252.10) |

MCS 21B
u
11-13

Date: Monday, 14/11/2005 8:52:31 AM
 User: Alba Panzuto

Process Sheet

| | | | |
|----------------------------------|---------------------------------------|-------------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : ARM WELDMENT |
| Job Number | : 23640 | | |
| Estimate Number | : 10450 | | |
| P.O. Number | : | Part Number | : D3379041 |
| This Issue | : 14/11/2005 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3379 REV C |
| First Issue | : / / | Project Number | : |
| Previous Run | : | Drawing Revision | : C |
| | Type : LARGE FAB ASSY | Material | : |
| Written By | : | Due Date | : 30/11/2005 |
| Checked & Approved By | : | Qty: | 2 |
| Comment | : Est A 05.02.03 New issue KJ/JLM | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|----------------|
| 1.0 | D3379043 | Lever Assembly |
|-----|----------|----------------|

| | | |
|-----|--------|---------|
| 2.0 | D33791 | Support |
|-----|--------|---------|

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|

**Comment:** LARGE FABRICATION RESOURCE 1

Assemble and weld using welding Jig DT8764 as per Dwg D3379

Identify as D3379-041

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|

**Comment:** POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask holes

| | | |
|-----|-----|---|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|

**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

| | | |
|-----|-------------|-----------------------|
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Monday, 14/11/2005 8:52:31 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM WELDMENT

Job Number: 23640

Part Number: D3379041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

